

Work Order ID 72483

Tuesday, July 26, 2011 11:49:46 AM



~~U/R~~

Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID: ~~U/R~~

Stop



Item Name: Support

Start Date: 7/26/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2892

Rev A U/R

ECN 11.615 W

100

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA082 Tumble & Deburr

SL 11-08-11

14

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 11-08-11

14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

and 11/08/11

14

130

140

*spray print
see attached drawing Rev. B*

QC 14

ET 11-08-11

12 11-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72483

Tuesday, July 26, 2011 11:49:46 AM



Page 2

Item ID: D2892-1

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Support

Start Date: 7/26/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: _____ FINISH TIME: _____	0.00 N/A 0.00 OVEN TEMPERATURE: _____ FINISH TIME: _____ u							
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>X Holes</u> Memo <u>wry</u>	0.00 0.00							

85 11-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72483

Tuesday, July 26, 2011 11:49:46 AM



Page 3

Item ID: D2892-1

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Support

Start Date: 7/26/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18
11-08-17
(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 26, 2011 11:49:15 AM

Page 1

Work Order ID: 72483



Parent Item: D2892-1



Parent Item Name: Support

Start Date: 7/26/2011



Required Date: 8/26/2011

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP C 02.11.26 Added P/O KJ
IPP D 08.03.19 Re-format EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077  D2892-1 TURNING DETAIL		Manufactured	No			110	Each	7.0000	0.5	7			
										SL		11-08-10	

Location

Loc Qty

Loc Code

MAT

7

70097

7

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

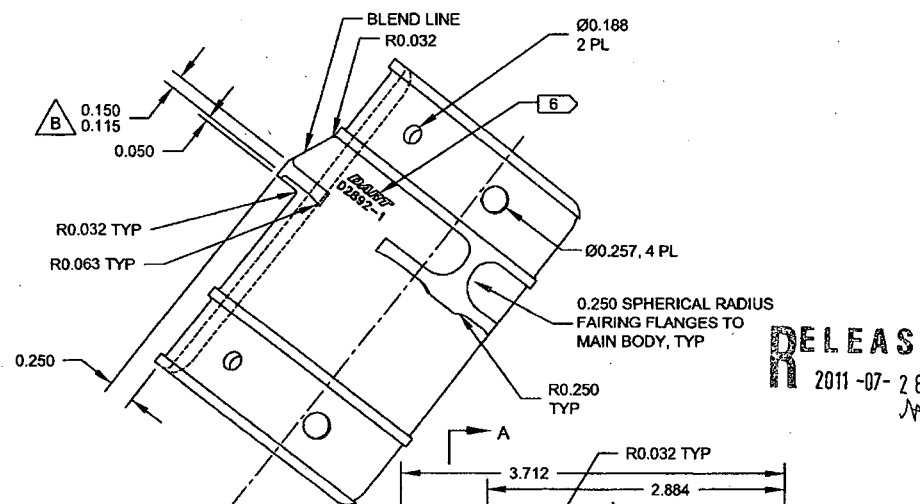
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

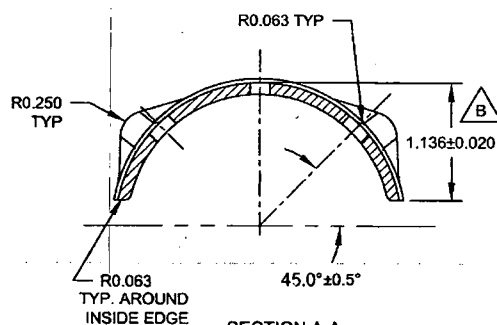
6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.41 lb

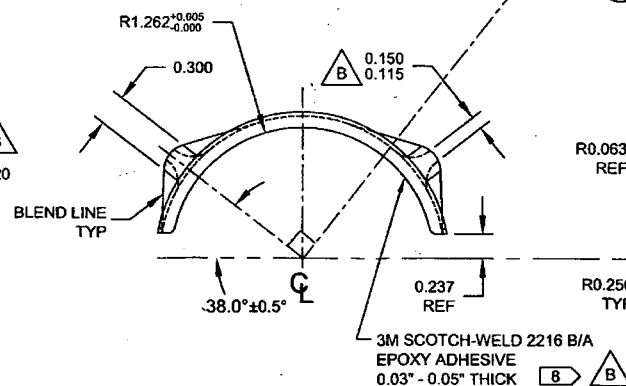
8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



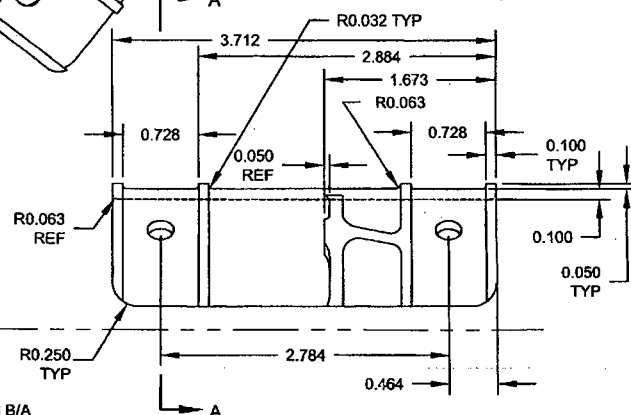
RELEASED
2011-07-28



SECTION A-A



D2892-1 SUPPORT



B	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION, UPDATE TOLERANCE (ZN D5-1,B5-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	40		
DRAWN	40		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2892	REV. B SHEET 1 OF 1
TITLE Ø2.500 SUPPORT	
SCALE NTS	

COPYRIGHT © 2000 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

DART AEROSPACE LTD		Work Order:	72483
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: AB ECD11-615	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.300	.300	.300	.300	.300
AC	0.040	0.060		.046	.046	.046	.048	.044
AD	0.115	0.135		.126	.126	.126	.126	.126
AE	0.240	0.260		.250	.250	.252	.251	.254
AF	0.188	0.193		.189	.189	.189	.189	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.138	1.136	1.140	1.139	1.137
AI	0.454	0.474		.465	.465	.466	.466	.467
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.257	.257	.257	.257	.257
AM	1.663	1.683		1.675	1.675	1.676	1.676	1.675
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: Date: 11-08-10

Audited by: Date: 11/08/11

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	72483
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: AB ECN11-6/S	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.300	.300	.300	.300	.300
AC	0.040	0.060		.044	.043	.042	.045	.044
AD	0.115	0.135		.126	.126	.126	.126	.126
AE	0.240	0.260		.254	.252	.252	.251	.251
AF	0.188	0.193		.189	.189	.189	.189	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.140	1.139	1.137	1.142	1.139
AI	0.454	0.474		.467	.468	.468	.466	.466
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.257	.257	.257	.257	.257
AM	1.663	1.683		1.675	1.675	1.675	1.675	1.675
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:	JL	Date:	11-08-10
Audited by:	amf	Date:	11/08/11
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	72483
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: AB ECD11-615	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	5
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	
AB	0.290	0.310		.300	.300	.300	.300	
AC	0.040	0.060		-.048	-.048	-.047	-.047	
AD	0.115	0.135		-.126	-.126	-.126	-.126	
AE	0.240	0.260		-.251	-.253	-.251	-.252	
AF	0.188	0.193		-.189	-.189	-.189	-.189	
AG	0.240	0.260		-.250	-.250	-.250	-.250	
AH	1.126	1.146		1.139	1.138	1.137	1.135	
AI	0.454	0.474		.466	.466	.466	.466	
AJ	0.240	0.260		-.250	-.250	-.250	-.250	
AK	0.053	0.073		-.063	-.063	-.063	-.063	
AL	0.257	0.262		-.257	-.257	-.257	-.257	
AM	1.663	1.683		1.675	1.675	1.676	1.676	
AN	0.053	0.073		-.063	-.063	-.063	-.063	
AO	0.022	0.042		-.032	-.032	-.032	-.032	
AP	2.779	2.789		2.784	2.784	2.784	2.784	
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: <u>SL</u>	Date: 11-08-10
Audited by: <u>ML</u>	Date: 11/08/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	